

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000117**Date Inspected:** 03-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, California**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record tests. The following items have been observed,

1) Today's observations are a continuance of procedure qualification record tests. Today's PQR test is identified as ABF-PQR-001-1. This PQR test is being attempted in the 1G position, as an AWS D1.5 single vee groove that is of one inch thick steel plate with a 10mm thick steel backing bar. Actual welding on the PQR test plate assembly did not occur until 1410. From 0700 until such time ABF and the CWI listed were observed practicing on scrap steel plate in an effort to establish welding parameters and methods for communicating the travel speed between the CWI and the welder.

2) Caltrans QA Inspector observed the following personnel present, Smith Emery Certified Welding Inspector Mr. Michael Johnson, ABF Welding Superintendent Mr. Tommy Gibson and also welders Mr. Juan Andrade Ortega and Dan Gordon.

3) New flux cored arc welding, welder Mr. Dan Gordon performed the welding on the PQR test plate while Mr. Juan Andrade Ortega performed the fit-up of future PQR test plate assemblies.

The visual observation of today's PQR test plate assembly is a significant positive difference from the previously observed PQR tests.

For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures that support today's observations are included within the TL-6032.

Summary of Conversations:

1) Mr. Tommy Gibson voiced that PQR testing would resume on Wednesday 04-04-2007.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Cuellar,Robert
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Quality Assurance Inspector

Reviewed By:	Smith,Ryan
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QA Reviewer
